

Date: Tuesday, 1/3/2006 4:20:34 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT CAP	
Job Number :	25381			
Estimate Number :	10312			
P.O. Number :	NIA	Part Number :	D2646	
This Issue :	1/3/2006	Drawing Number :	D2646 REV B	
Prsht Rev. :	NC	Project Number :	N/A	
First Issue :	NIA	Drawing Revision :	B	
Previous Run :	23370	Material :	NIA	
Written By :	<i>SEE COMMENT BELOW</i>		Due Date :	1/28/2006
Checked & Approved By :	<i>SEE ABOVE USER & DATE</i>		Qty:	50 Um: Each
Comment :	Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *00000341*

1-Spin as per Dwg D2646

2-Material release note required

2.0	D2646	Aft Cap
-----	-------	---------



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to 0.391" and c/sink as per Dwg D2646.

3-Deburr

0.250"

SP 06/01/20

SP 06/01/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/05/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 25381

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06/01/2006

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06-02-22

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/28

(50)

9.0

NAS1330C3KB116

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

NAS1330C3KB116

Insert

or AE5510KB116

89XM19014
11 XM19349

DL 06/04/28

(50)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

DL 06/04/28

(50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-02 (50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 4

DL 06/05/02

(50)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/05/02

(50)

DL 06-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

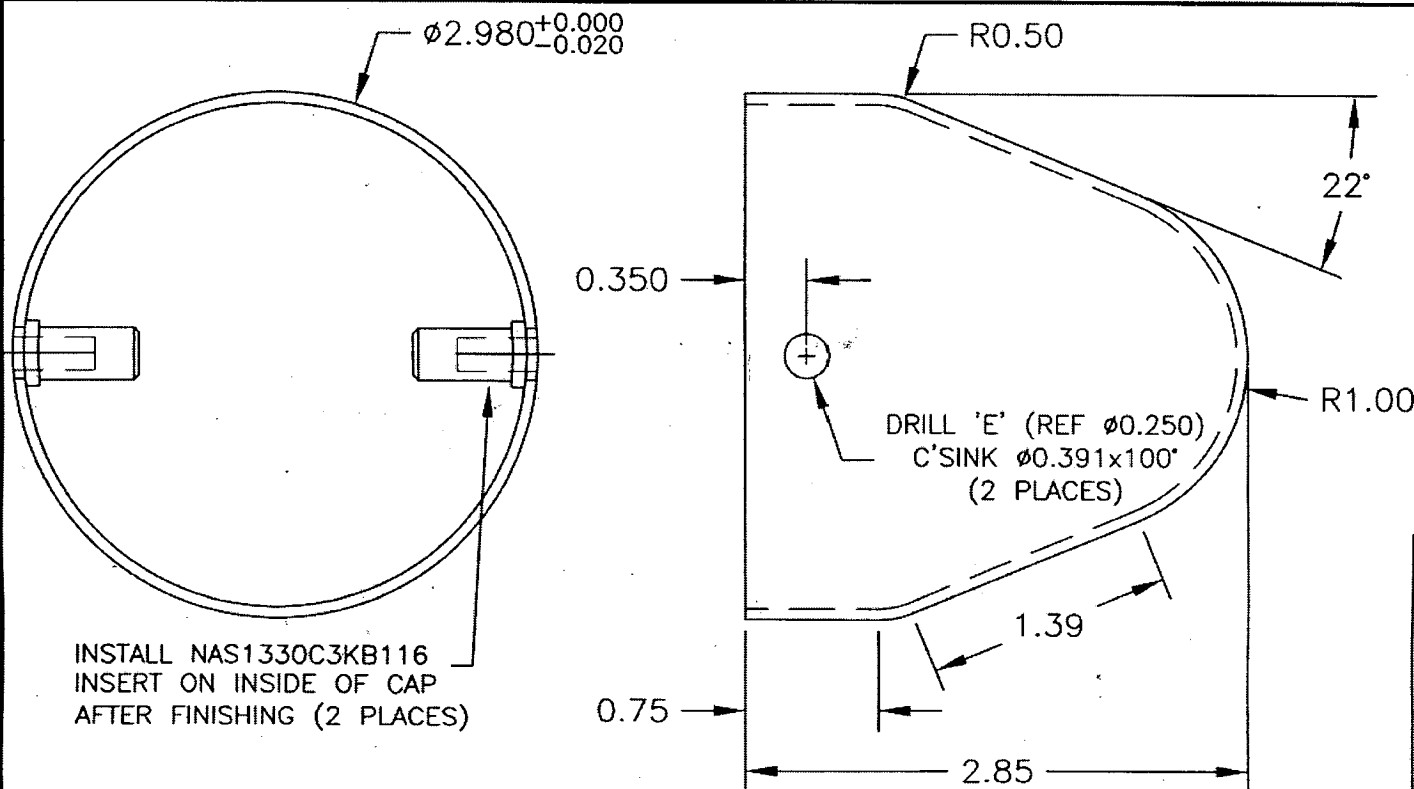
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
DS	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D2646	SHEET 1 OF 1
05.04.01		TITLE	SCALE
		AFT CAP	1:1
A	97.03.25	NEW ISSUE	
B	05.04.01	CHANGE TO CLOSED INSERTS	



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-09

UNCLASSIFIED
EXCEPT TO THE
EXTENT INDICATED
WORK CENTER
NO. 25381

06.01.19



Alcoa Mill Products

1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

051345-7
R CA7197

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS
8307 TRIAD DR
GREENSBORO, NC 27410

CERT NO 0000615298
DATE 12/21/2004
SKID NO 336756
SKID WGT 10,029
PAGE 1 OF 1

ORDER NO	LB6427	PO NO	CA7197			MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 242284 COIL: B01 DROP: 449326

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4493262	0.09	0.41	0.08	0.02	0.008	0.002	0.009	0.006	0.02

HEAD ULTIMATE STRENGTH 12.8 KSI
TAIL ULTIMATE STRENGTH 13.1 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.7 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 34 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

Feb 21-05

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **